

Date: Friday, 23/05/2008 9:53:10 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BELL CRANK
<b>Job Number</b> : 39434	
<b>Estimate Number</b> : 11967	
<b>P.O. Number</b> :	<b>Part Number</b> : D2056
<b>This Issue</b> : 23/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2056 REV B2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B2
<b>Previous Run</b> : 37727	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/06/2008 <b>Qty:</b> 30 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08.5.23</u>	
<b>Comment</b> : Est. E 02.04.04 Added Rev.B2 NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
-----	--------------------	--------------------------



**Comment:** Qty.: 0.2494 f(s)/Unit Total : 7.4813 f(s)  
 6061-T6 Bar 1.25 x 1.25"  
 Material: 6061-T6, 1.250" x 1.250"

Batch: M107744

ml 08/06/21

(30)

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW  
 Cut blanks 2.80" long

ml 08/06/21

(30)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio D2056  
 Tumble  
 Deburr any rough edges after tumbling

ml 08/06/21

(30)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/06/21

(30)

5.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S 08/06/23

counter

(x30)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/05/2008 9:53:10 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 39434

Part Number: D2056

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*MF 08/06/23*

*30X*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

*7:35*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*8:05*

*FL 08/06/24*

*(30)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*MF 08/06/24*

*(30X)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 10*

*AS 08/06/25*

*(X30)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/06/25*

Job Completion



*mf 08-06-25*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39434
<b>Description:</b> Bell Crank		<b>Part Number:</b> D2056
<b>Inspection Dwg:</b> D2056	<b>Rev:</b> B2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.750	✓			
0.900	+/-0.010	.900	✓			
1.000	+/-0.010	1.001	✓			
0.125	+/-0.010	.126	✓			
0.060	+/-0.010	.061	✓			
Ø0.191	+0.005/-0.001	.191	✓			
0.362	+/-0.010	.365	✓			
0.750	+/-0.010	.750	✓			
0.385	+/-0.010	.385	✓			
Ø0.257	+0.006/-0.001	.260	✓			
0.100	+/-0.010	.100	✓			
0.300	+/-0.010	.300	✓			
0.946	+/-0.010	.946	✓			
0.750	+/-0.010	.750	✓			
0.075	+/-0.010	.075	✓			
2.637	+/-0.010	2.637	✓			
0.375	+/-0.010	.375	✓			
Ø0.513-0.518	0.513 - 0.518	.518	✓			
R0.450	+/-0.010	.450	✓			
R0.125	+/-0.010	.125	✓			
R0.200	+/-0.010	.200	✓			
R0.550	+/-0.010	.550	✓			
R0.263	+/-0.010	.263	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> J.P.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/06/20	<b>Date:</b> 08/06/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

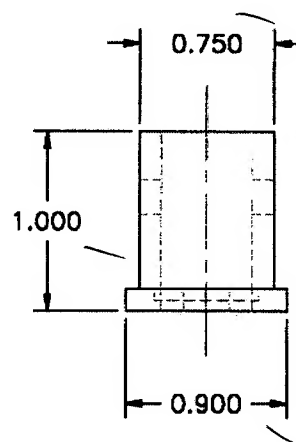
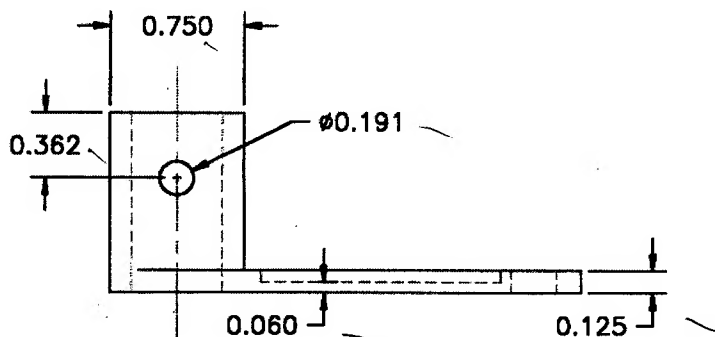
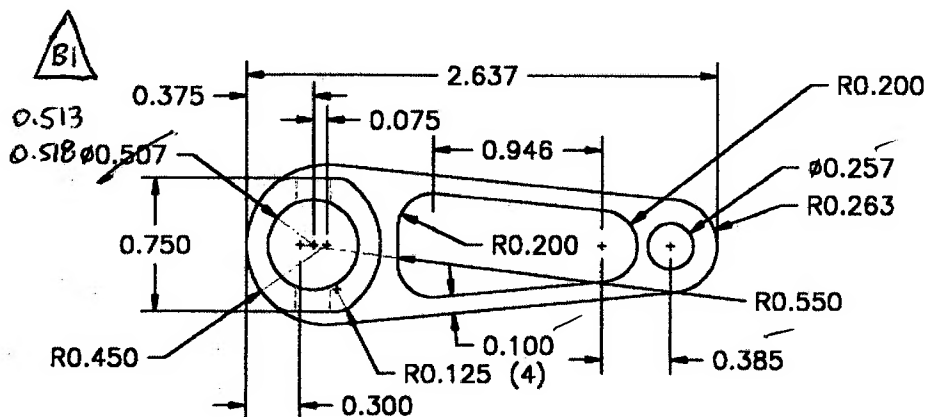
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
99.04.28 *AE*

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>AE</i>	<i>AE</i>	D2056	
DATE	TITLE	SCALE	
92.03.13	BELL CRANK	1:1	
B	95.11.02	RE-DESIGN	
B1	<i>AE</i> 01.06.04	MODIFY HOLE SIZE, ADD PIC OPTIM	
B2	<i>AE</i> 01.12.20	ADD NOTE ON TOLERANCES	



**B1** ACID ETCH & ALDINE PER  
DART QSI 005 4.1  
POWDER COAT BLACK SHIMMER  
(4.3.5.7) PER DART  
QSI 005 4.3

**B2**

MATERIAL: 6061-T6 (QQ-A-225/B)  
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries